

What is claimed is:

1. A press comprising:
an upper platen and a heated lower platen that are selectably movable toward and away from each other for conformally but nondeformingly receiving a vessel therebetween so that vessel surfaces in conformal contact with the upper platen and the lower platen remain substantially undeformed while the vessel is filled with a pressurized material; and
wherein a portion of the vessel is heated to at least a predetermined temperature by the heated lower platen.
2. The press of claim 1, wherein the vessel is a roof assembly.
3. The press of claim 2, wherein surfaces of the roof assembly in conformal contact with the upper platen and the lower platen are non-parallel.
4. The press of claim 1, wherein the vessel is an angled roof assembly.
5. The press of claim 4, wherein the angled roof assembly is for use with an air handling unit.
6. The press of claim 1, wherein the heated lower platen is heated by heated fluid.
7. The press of claim 1, wherein the heated lower platen is heated by heating elements.
8. The press of claim 1, wherein the pressurized material is an injected foam material.
9. The press of claim 8, wherein a portion of the vessel is sufficiently heated by the heated lower platen to promote substantially uniform expansion and curing of the injected foam within the vessel.
10. The press of claim 8, wherein a portion of the vessel is sufficiently heated by the heated lower platen to promote bonding between the injected foam and the heated portion of the vessel.
11. The press of claim 1, wherein the temperature of the heated lower platen is less than the flash point temperature of the injected material.

12. The press of claim 1, wherein the upper platen comprises at least two movable portions.
13. The press of claim 12, wherein the at least two movable portions are hingedly connected.
14. The press of claim 13, wherein one of the at least two movable portions may be rotated independently of the remaining portions of the at least two movable portions.
15. The press of claim 13, wherein a graduated indicator having at least one graduated indication corresponding to a feature of the vessel is used to position the at least two movable portions.
16. The press of claim 15, wherein the feature of the vessel is the length of the vessel.
17. The press of claim 1, further comprising a plurality of rollers extending through the lower platen for receiving the vessel between the upper platen and the lower platen.
18. The press of claim 13, further comprising at least one device associated with a hinged connection to selectively prevent rotational movement in a predetermined direction of one of the at least two movable portions.
19. The press of claim 18, wherein the at least one device is a cam.
20. The press of claim 19, wherein the cam is selectively actuated by at least one actuator.
21. A method of filling a vessel with a pressurized material, the steps comprising:
 - providing a press having an upper platen and a heated lower platen that are selectably movable toward and away from each other;
 - securing a vessel conformally but nondeformingly between the upper platen and the heated lower platen so that a portion of the vessel is heated to at least a predetermined temperature by the heated lower platen; and
 - filling substantially the vessel with a pressurized material so that vessel surfaces in conformal contact with the upper platen and the lower platen

remain substantially undeformed while the vessel is substantially filled with a pressurized material.

22. The method of claim 21, wherein the vessel is an angled roof assembly.
23. The method of claim 22, wherein the angled roof assembly is for use with an air handling unit.
24. The method of claim 21, wherein the step of filling substantially the vessel includes filling substantially the vessel with an injected foam.
25. The method of claim 21, wherein the step of securing the vessel so that a portion of the vessel is heated to at least a predetermined temperature by the heated lower platen includes the heated portion of the vessel promoting substantially uniform expansion and curing of the pressurized material filling substantially the vessel.
26. The method of claim 25, wherein the pressurized material is an injected foam material.
27. The method of claim 21, wherein the step of securing the vessel so that a portion of the vessel is heated to at least a predetermined temperature by the heated lower platen includes the heated portion of the vessel promoting bonding between the pressurized material and the heated portion of the vessel.
28. The method of claim 27, wherein the pressurized material is an injected foam.
29. The method of claim 27, wherein at least a predetermined temperature is above about 115°F.